



Dart Aerospace Ltd.
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D135-1027-243
Job Sheet 170195

Accounting Job RD17-1027-01



Part No: D135-1027-243

Job Qty: 1 ea

Part Name: MID HEIGHT AFT Crosstube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: R+D

Description:

Note: D135-1027-243 REV.B IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP IPP REV:B 17.10.24 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/18/18	0.00	0.00	Start Up Container		
100	HandFinish	1 pcs		1/18/18	0.00	0.25	HandFinish1		N/A 4/18/1/30
110	QC	1 pcs		1/18/18	0.00	0.00	QC7-1		N/A 4/18/1/30
120	HandFinish	1 pcs		1/18/18	0.00	0.25	HandFinish4		N/A 4/18/1/30
130	QC	1 pcs		1/18/18	0.00	0.00	QC5		
140	SprayPaint	1 pcs		1/19/18	0.00	1.00	Spray Paint		N/A 4/18/1/30
150	QC	1 pcs		1/19/18	0.00	0.00	QC14		N/A 4/18/1/30
170	Packaging	1 pcs		1/19/18	0.00	0.00	Packaging3-1	TEST ONLY	N/A 4/18/1/30
180	QC21-SA	1 Ea		1/19/18	0.00	0.00	QC21		met. 18/01/31

AN 3 1 70

Part Op 100 - ***PRIOR TO CHEMICA CONVERSION*** SCRIBE DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4
Descriptions: 120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE
NUT AND CROSSTUBE USING SEALANT(NOTE10)
140 - ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE
PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: _____ 2- PAINT OUTSIDE SURFACE AS
PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: _____ 3- COAT INSIDE SURFACE WITH LPS
PROCYON AS PER DWG QSI005 4.8.4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE
WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

NOT
REQ'D
mtd
18/01/24

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D135-1027-253 2035585	1	0	0	0
	D5511-1	3	7	0	0
	MS35650-304	6	60	0	0
	NAS1149D0363J	6	4,315	0	0

Not req'd
N/A 4/18/1/30

Part Specifications

Specifications could not be found.



S037300



MID HEIGHT AFT Crosstube Assembly

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CANADA

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PART NO: D135-1027-243

Original Serial #: S037300

Revision:

Operation: Start up Operation 01/31/18

Change No: CHG001

Job No: 170195